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WORLD INTELLECTUAL PROPERTY ORGANIZATION  
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY - PCT

(51) International Patent Classification 5:

C09D 5/14

A1

(11) International Publication Number:

WO 91/15546

(21) International Application Number:

PCT/GB91/00561

(43) International Publication Date:

17 October 1991 (17.10.91)

(22) International Filing Date:

9 April 1991 (09.04.91)

5DE (GB)

(30) Priority data:

9008055.2

10 April 1990 (10.04.90)

GB

(71) Applicant *for all designated States except US*: COURTAULDS COATINGS (HOLDINGS) LIMITED [GB] 18 Hanover Square, London W1A 2BB (GB).

(72) Inventors; and

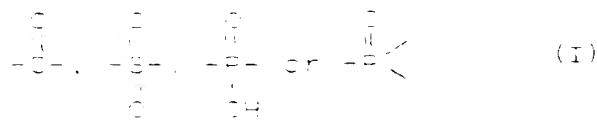
(75) Inventors/Applicants *(for US only)*: GREEN, Georgina, Elizabeth [GB] (GB); 10 South Fork, Lemington Rise, Newcastle-upon-Tyne NE15 8TZ (GB); REID, James [GB] (GB); 150C Whitehall Road, Gateshead, Tyne and Wear NE8 1TP (GB); ARNOLD, David, Edward, James [GB] (GB); 132 Morpeth North, Fenham, Newcastle-upon-Tyne NE4 9DY (GB); HUNTER, Julian, Edward [GB] (GB); 32 Elsing Close, Meadow Rise, Kenton, Newcastle-upon-Tyne NE5 4SW (GB).

(81) Designated States: AT (European patent), BF (European patent), CH (European patent), DE (European patent), DK (European patent), ES (European patent), FR (European patent), GB (European patent), GR (European patent), IT (European patent), JP, KR, LI (European patent), NL (European patent), NO, SE (European patent), US.

Published

*With international search report.*

(54) Title: ANTIOUTG COATING COMPOSITIONS



(57) Abstract

An antioutg coating composition, comprising a polyolefinic resin, a metal having a valency of at least 2, a nitrogen atom, and a nitrogen atom, which nitrogen atom is bonded to the metal, and a polymer. The polymer may contain one or more substituents on the vinylidene linkage, which substituents may be hydroxyl, carboxyl, or alkyl groups.

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## ANTIFOULING COATING COMPOSITIONS

## Technical Field

This invention is concerned with antifouling coating compositions used on surfaces likely to come into contact with marine fouling organisms such as algae, seaweed and barnacles, for example on ships or boats or on the outfalls for cooling water from power stations. Such coating compositions generally comprise a biocide for marine organisms and a binder polymer.

## 10 Background Art

There have been many suggestions in recent years for self-polishing antifouling paints having binders which are linear polymers containing pendant side groups which are liberated from the polymer by reaction with seawater, the residual polymer being sufficiently dispersible or soluble in seawater to be swept away from the paint surface, exposing a fresh layer of the binder able to undergo a similar reaction with seawater. Such paints are described for example in GB-A-1457580. The gradual thinning of the paint film controls the release of a biocide active against fouling. The only commercially significant self-polishing paints employ binders which comprise triorganotin ester leaving groups.

EP-A-204456 describes a hydrolysable resin for use in antifouling coatings consisting of a resin having at least one side chain bearing at least one terminal group of the formula:

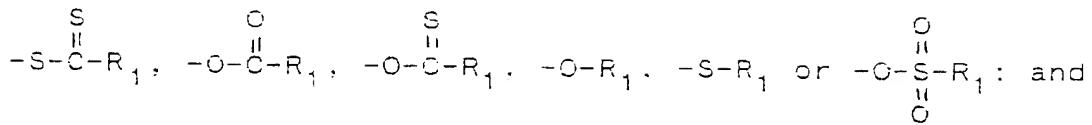


wherein  $\text{R}$  represents  $\text{CH}_2=\text{CH}-$ ,  $\text{CH}_2=\text{CH}_2-$ ,  $\text{CH}_2=\text{CH}-\text{CH}_2-$  or  $\text{CH}_2=\text{CH}-\text{CH}_2-\text{CH}_2-$

$\text{M}$  is a metal selected from zinc, copper and tellurium and  $\text{R}'$  is an integer of 1 to 10,  $\text{R}'$  representing an organic group.

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residue selected from:



5 R<sub>1</sub> is a monovalent organic residue.

EP-A-342276 describes a process for preparing such a metal-containing resin composition comprising reacting a mixture of:

(A) an acid group-containing resin;

10 (B) a metallic salt of a low-boiling organic acid, in which the metal is selected from those having 2 or more valences and a lesser ionization tendency than those of alkali metals; and

(C) a high-boiling organic monobasic acid;

15 at an elevated temperature while removing the formed low-boiling organic basic acid out of the system.

US-A-2490925 discloses a pest-control composition comprising stabilised rosin amine or a co-ordinate covalent metal salt thereof dispersed in kerosine, gasoline, benzene, alcohol, acetone, water or pine oil. The composition is stated to be particularly effective as a fungicide. The composition can be added to marine paint containing a dehydroabietylamine complex of copper acetate.

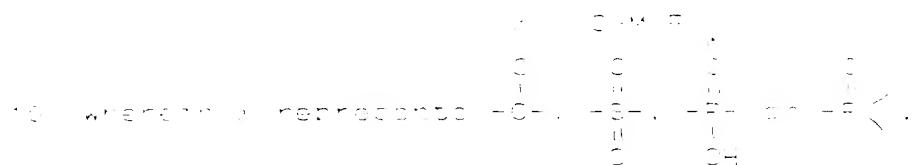
JP-A-54-64633 describes a marine antifouling biocide which is a long-chain (12 to 18 carbon atoms) linear aliphatic primary amine or salt thereof. JP-A-54-110322 describes certain long-chain (12 to 18 carbon atoms) linear aliphatic secondary and tertiary amines as marine antifouling agents.

30 US-A-4675051 describes a marine antifouling paint which is gradually dissolved in seawater and which comprises a binder which is a resin produced by the reaction of rosin and an aliphatic polyamine containing at least one

For more information on the 2009-2010 school year, contact the Office of the Superintendent at 207-783-4000.

1. *What is the relationship between the two variables?* (e.g., positive, negative, etc.)

46 antifouling coating composition according to the  
present invention containing a biocide for marine organisms  
and substances as milder as hydrophobic resins having at  
least one side-chain bearing at least one terminal group  
of the formula:



$M$  represents a metal having a valency of at least 1,  $R$  represents  $-\text{CH}_2-$  or  $\text{H}_2\text{C}-$ , and  $R'$  represents a monobasic organic acid residue, and is characterised in that it contains a substantially non-volatile amine.

In the hydrolysableester the metal carbonate form of zinc is selected from the total zinc present in the sample.

The linkage is to be preferably a  $\text{C}-\text{O}-\text{C}$  linkage. The polyimide may, for example, be produced by the process of EP-A-1641176 by reacting an acid group-containing diamine, diether, or a carboxylic acid containing diamine with a metallic salt of a low-boiling organic acid and with a diamine or a polyamine.

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carboxylic-acid-functional polymer of equivalent weight 240 to 600. A preferred acid-functional polymer is an addition copolymer of one or more olefinically unsaturated acids or anhydrides, for example acrylic acid, methacrylic acid, 5 maleic acid, maleic anhydride, fumaric acid, itaconic acid or itaconic anhydride, vinyl benzoic acid (for example p-vinyl benzoic acid), 3-butenoic acid or beta-carboxy-ethyl acrylate or methacrylate, with at least one olefinically unsaturated comonomer. Copolymers of methacrylic acid or 10 acrylic acid are preferred. (The preferred equivalent weight of 240 to 600 corresponds to an acrylic acid content of 14.3 to 35.8% by weight and a methacrylic acid content of 16.7 to 41.7% by weight). The acid monomer is preferably copolymerised with one or more comonomers which are 15 unreactive with acid groups, for example acrylic or methacrylic esters such as methyl acrylate, methyl methacrylate, ethyl acrylate, butyl acrylate or 2-ethylhexyl methacrylate, styrene, acrylonitrile, vinyl acetate, vinyl butyrate, vinyl chloride, or vinyl pyridine. Terpolymers 20 may be preferred, for example methyl methacrylate or ethyl methacrylate, which tend to form a hard film, can be used in conjunction with an acrylate such as ethyl acrylate or particularly an alkyl acrylate of 3 to 8 carbon atoms in the alkyl moiety such as butyl acrylate, which helps to 25 form a more flexible film. Such an acid polymer preferably has a molecular weight of 1,000 to 100,000. The equivalent weight of the acid polymer (calculated as acid groups) is most preferably 300 to 440, equivalent to an acrylic acid or methacrylic acid content of about 20 to 30% by weight.

30 Alternative carboxylic acid-functional polymers are alkyd resins.

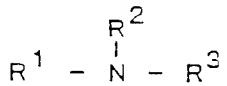
Alternative acid-functional polymers are polymers containing sulphonic acid, phosphonic acid or phosphoric acid (acid phosphate) groups. If alternative acid groups 35 are used they are also preferably present in an addition polymer, for example an addition copolymer of an olefinic-

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at least 8, for example 12 to 20, carbon atoms, for example lauric, stearic, oleic, linoleic, ricinoleic or 12-hydroxystearic acid; alternative carboxylic acids include benzoic, salicylic, nitrobenzoic, chloroacetic, dichloro-5 acetic or chlorobenzoic acid. The acid can be a mixture of carboxylic acids such as the mixed aliphatic carboxylic acids sold as naphthenic acid or versatic acid, or a mixture of acids derived from a natural fat or oil. Alternative acids include toluenesulphonic, beta-naph-10 thalenesulphonic, p-chlorobenzenesulphonic, dimethyldithiocarbamic and diethyldithiocarbamic acid.

The base resin, metallic salt and high-boiling acid are generally reacted at a temperature above the boiling point of the low-boiling acid but below the boiling point of the high-boiling acid to form the hydrolysable resin. The reaction is preferably carried out in an organic solvent, for example a hydrocarbon such as xylene or trimethylbenzene, a ketone such as methyl isoamyl ketone or an ester such as butyl acetate, ethoxyethyl acetate or methoxypropyl acetate.

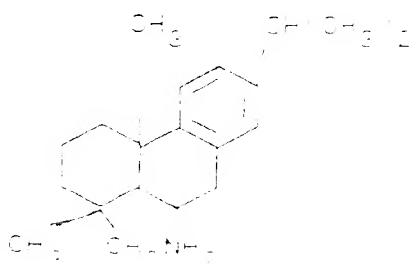
The amine used in the coating composition is substantially non-volatile at ambient temperature (20°C) and standard pressure. Preferably, it has a boiling point of at least 200°C, most preferably at least 250°C. The amine is preferably a monoamine and is preferably a primary amine, although a secondary or tertiary amine can be used. The amine preferably includes at least one organic group containing at least 10 carbon atoms, more preferably 12 to 20 carbon atoms. Such amines generally have the advantage that they are toxic to marine organisms. The amine can for example be a diterpene-derived amine of the formula:



35 where  $R^1$  is a monovalent hydrocarbon group derived from a diterpene and  $R^2$  and  $R^3$  are each independently hydrogen, an alkyl group having 1 to 18 carbon atoms or an aryl group

having 6 to 12 carbon atoms. Such an amine is phenoxazin, derived from rosin. A phenoxazin amine derived from rosin is denverosabatetraamine and is commercially as "Rosin Amine D". Its main constituent is:

5



4. Corresponding secondary or tertiary amine, for example an N-methyl or N,N-dimethyl derivative of Rosin Amine D, can 10 alternatively be used. The diphenyl amines are effective marine biocides. The amine can alternatively be an aliphatic amine containing an organic group of 12 to 20 carbon atoms, for example a straight-chain alkyl or a ketyl primary amine such as dodecyl amine, hexadecyl amine, 15 octadecyl amine or oleyl amine or mixtures of amines derived from aliphatic groups present in natural fats and oils such as tall oil amine or hydrogenated tall oil amine or coconut amine (coco-amine) or a corresponding secondary amine or tertiary amine such as N-methyl dodecyl amine or 20 N,N-dimethyl coco-amine. The long chain aliphatic amines having 12 to 16 carbon atoms are very effective marine biocides. Alternative amines which can be used are anilines such as those sold commercially as "phenylamines", or hydroxyl-substituted amines such as triethanolamine or diethanolamine.

The antifouling coating composition is preferably applied as a solution in an organic solvent, for example a hydrocarbon such as toluene or white spirit, alcohols such as methyl, isopropyl, ethyl or tertiary isobutyl alcohol, or aldehydes such as isobutanal, ethoxyethanal or methylglyoxal or an ester such as butyl acetate, ethyl, isopropyl acetate or methyl, isopropyl acetate. When the solvent

lysable resin binder is prepared in an organic solvent the resin solution can be used directly in preparing the paint. It can optionally be diluted by further solvent, preferably selected from the solvents listed above.

5 The non-volatile amine has the advantage that it reduces the viscosity of solutions of the hydrolysable resin in organic solvents such as those listed above. The amine is believed to react at least in part to form a co-ordination complex with the metal M in the hydrolysable 10 resin. In the co-ordination complex the metal M may be co-ordinately bonded both to the amine as ligand and to an anion, for example a carboxylate anion, acting as organic acid residue R. For those metals which form colourless hydrolysable resin solutions complex formation can be seen 15 by a colour change. Solutions of hydrolysable resin in which the metal M is copper, for example, are generally green in the absence of amine but change colour to blue when the amine is added. The amine can reduce the viscosity of the hydrolysable resin solution by a factor of up 20 to 4. The amine can thus be used with hydrolysable resin solutions which without amine are too viscous to form the basis of a sprayable paint, that is hydrolysable resin solutions which have an increased resin content. For example, the amine can be added to hydrolysable resin 25 solutions having a resin content of 30 to 35 per cent by volume to produce solutions whose viscosity is equal to that of hydrolysable resin solutions without amine having a resin content of 25 to 30 per cent by volume. Moreover, since the amine is non-volatile it also directly increases 30 the non-volatile content of the coating composition. There has been recent pressure for the use of a reduced content of volatile organic solvent in various types of coating compositions.

35 The proportion of hydrolysable resin to amine in the coating composition is preferably from 98:2 to 10:90 by volume, most preferably from 90:10 to 30:70. Amines having

10 film-forming properties are preferably used at no more than 40% based on the combined weight of polymer and amine, whereas film-forming amines such as the diterpene derivatives can be used at a higher proportion if desired. More than one amine can be used; for example a diterpene amine can be used with a long-chain aliphatic amine.

15 If an amine which is biocidal to marine organisms is used, the resulting coating composition comprising hydrolysable resin and amine can be used as a clear antifouling varnish or can be pigmented. If the metal M in the hydrolysable resin is a metal which is toxic to marine organisms, for example copper, it can augment the marine biocidal properties of the coating, although since the metal content of the hydrolysable resin is only for example 10 to 16 15% by weight its effect may not be large.

20 If a non-biocidal amine is used the coating composition should contain a marine biocide. The coating preferably contains a pigment, and the same material may function simultaneously as a marine biocide and as a pigment if a biocidal pigment is used.

25 The amine is preferably pre-mixed with the hydrolysable resin binder before addition of other components of the coating. The hydrolysable resin binder solution can alternatively be mixed simultaneously with the amine and with the pigment. For example, the hydrolysable resin solution and the amine can be mixed with pigment using conventional paint blending procedures to provide a composition having a pigment volume concentration of, for example, 25 to 55%. The pigment is preferably a sparingly 30 soluble pigment having a solubility in seawater of from 0.5 to 100, most preferably 1 to 10, parts per million by weight, and is preferably a metal-liferous pigment. The pigment is most preferably a copper or zinc compound, for example cuprous oxide, cuprous nitroprussate, zinc oxide, zinc chromate, zinc carbonate, zinc citrate, zinc borate

bamate, cuprous ethylene bis(dithiocarbamate) and zinc ethylene bis(dithiocarbamate). These sparingly soluble pigments which are copper and zinc compounds are generally also marine biocides. The sparingly soluble metalliferous 5 pigments produce water-soluble metal compounds on reaction with seawater so that the pigment particles do not survive at the paint surface. Mixtures of sparingly soluble pigments can be used, for example cuprous oxide, cuprous thiocyanate or zinc ethylene bis(dithiocarbamate), which 10 are highly effective biocidal pigments, can be mixed with zinc oxide, which is less effective as a biocide but dissolves slightly more rapidly in seawater.

The paint composition can additionally or alternatively 15 contain a pigment which is not reactive with seawater and may be highly insoluble in seawater (solubility below 0.5 part per million by weight) such as titanium dioxide or ferric oxide or an organic pigment such as a phthalocyanine 20 pigment. Such highly insoluble pigments are preferably used at less than 40% by weight of the total pigment component of the paint, most preferably less than 20%.

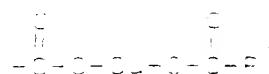
The anti-fouling paint can also contain a non-metalliferous biocide for marine organisms, for example tetra-25 methyl thiuram disulphide, methylene bis(thiocyanate), captan, a substituted isothiazolone, for example as described in GB-A-1575226, or 2-methylthio-4-t-butylamino-6-cyclopropylamino-s-triazine.

The invention is illustrated by the following Examples:

Examples 1 to 4

30 A 28.9% by volume solution A in a 4:1 xylene:butanol mixture of a hydrolysable resin based on a methacrylic acid copolymer with acrylate and methacrylate esters, in which the pendent carboxylic groups derived from the methacrylic

acid had been converted to



groups, wherein R' is derived from a high boiling aromatic carboxylic acid (naphthenic acid or similar), was mixed with Resin Amine D in the proportions shown in Table 1 below. The ratio of mixing is quoted as a volume ratio of hydrolysable resin to Resin Amine D on a dry weight basis. The green resin solution and colourless amine formed a blue solution, the blue colour being most intense at a mixing ratio of 40:60 (Example 3).

Table 1

Example No.	Mixing Ratio	Solids Content % by volume	Viscosity in mPa s
1	100:0	28.8	240
2	80:20	33.7	81
3	60:40	40.4	90
4	40:60	50.4	130
	20:80	67.0	180

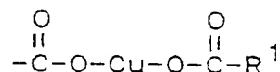
As shown in Table 1, the addition of Resin Amine D decreased the viscosity of the hydrolysable resin solution (Resin Amine D is itself a viscous liquid resin of viscosity well above 1000 mPa s). The products of Examples 1 to 4 can be used as clear antifouling varnishes. Alternatively, they can be mixed with pigments, for example iron oxide, cuprous tricyanate or zinc ethylene triurethane carbamate.

#### Examples 5 to 12

The process of Examples 1 to 4 was repeated using two

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different hydrolysable resin solutions, each being acrylic resins containing pendent groups of the form:



5 The viscosities after mixing are shown in Table 2. The hydrolysable resin solution B of Examples 5 to 8 had a solids content of 27.6% by volume and the solution C of Examples 9 to 12 a solids content of 29.5% by volume.

Table 2

10	Example No.	Mixing Ratio	Solids Content % by volume	Viscosity in mPa s
	(B)	100:0	27.6	240
	5	80:20	32.3	100
	6	60:40	38.9	100
15	7	40:60	48.8	260
	8	20:80	65.6	290
	(C)	100:0	29.5	360
	9	80:20	34.3	110
	10	60:40	41.0	120
20	11	40:60	51.1	180
	12	20:80	67.6	280

### Examples 13 to 21

Hydrolysable resin solution (A, B or C above), pigment and Rosin Amine D were mixed by conventional paint mixing technology in a high-speed disperser to form paints of the compositions shown in Table 3 (amounts of ingredients in % by weight).

The paints of Examples 13 to 21 were applied to primed steel panels and were immersed in seawater in an area rich in marine fouling. After 12 months' immersion they

resisted fouling by algae and animal fouling, whereas a non-toxic comparison panel showed heavy fouling.

The paints of Examples 10, 11 and 21 were applied as test patches below the waterline on the side of the hull of an oil tanker. After 11 months in service, mainly in tropical latitudes, the test patches were substantially free from algal and animal fouling, whereas a neighbouring patch not coated with antifouling paint was heavily fouled.

Table 3

<u>Example No.</u>	13	14	15	16	17	18	19	20	21
Hydrolysable Resin Solution	21.52(A)	22.47(B)	22.99(C)	26.38(A)	24.23(B)	24.64(C)	33.13(A)	34.12(B)	32.83(C)
<b>Rosin Amine D</b>	5.03	7.00	6.46	5.14	6.29	5.77	6.64	6.54	6.67
<b>Chlorinated paraffin plasticiser</b>	3.48	4.07	4.07	3.95	4.01	4.02	-	-	-
<b>Cuprous Oxide</b>	46.55	54.48	54.49	52.89	53.66	53.75	54.05	53.25	54.29
<b>Titanium Dioxide</b>	2.87	3.35	3.35	3.26	3.30	3.31	-	-	-
<b>Red Iron Oxide</b>	-	-	-	-	-	-	4.16	4.10	4.18
<b>Structuring Agents (bentonite, clay and silica)</b>	1.74	2.04	2.04	1.98	2.01	2.01	2.02	2.00	2.03
<b>Methyl Isobutyl ketone</b>	10.46	3.66	3.67	3.56	3.61	3.62	-	-	-
<b>Xylene</b>	8.36	2.93	2.93	2.85	2.89	2.89	-	-	-
<b>Volume ratio of hydrolysable resin to amine</b>	56:44	49:51	53:47	61:39	53:47	56:44	60:40	60:40	60:40
<b>% solids content by volume</b>	38.3	53.0	53.1	50.0	51.4	51.7	51.2	51.6	53.9
<b>Paint viscosity (poise)</b>	-	-	-	-	-	-	4.4	5.5	6.9

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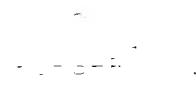


$\alpha$  represents a metal having a valency of at least 1,  $\beta$  represents 1 or 2, and  $\gamma$  represents a monobasic organic carboxylic acid, characterised in that the carboxylic acid is an alpha, beta-dicarboxylic acid.

## 2. An antifouling coating composition according to

Figure 1, in which  $\tau$  represents the hydrodynamic radius derived from a capillary flow measurement,  $\tau_0$  is the radius of gyration of the polymer chain, and  $\tau_1$  is the radius of gyration of the solvent molecule.

Figure 10 shows the effect of the number of hidden neurons on the performance of the proposed model. The number of hidden neurons is varied from 1 to 10. The results show that the performance of the model is not significantly affected by the number of hidden neurons. The model is able to learn the data with a small number of hidden neurons, and the performance is not significantly affected by increasing the number of hidden neurons.



wherein R<sup>1</sup> represents a monovalent organic residue linked through a carbon atom.

5. An antifouling coating composition according to  
claim 4, characterised in that the monobasic organic acid  
5 residue R is the residue of an aliphatic carboxylic acid  
having at least 8 carbon atoms.

6. An antifouling coating composition according to any of claims 1 to 5, characterised in that the substantially non-volatile amine includes at least one organic group having at least 10 carbon atoms

7. An antifouling coating composition according to claim 6, characterised in that the said organic group having at least 10 carbon atoms is derived from a diterpene.

15 8. An antifouling coating composition according to  
claim 6, characterised in that the substantially non-  
volatile amine is an aliphatic amine containing an organic  
group of 12 to 20 carbon atoms.

9. An antifouling coating composition according to  
any of claims 1 to 8, characterised in that the proportion  
of hydrolysable resin to amine in the coating composition  
is from 90:10 to 30:70 by volume.

10. An antifouling coating composition according to  
any of claims 1 to 9, characterised in that the amine is  
25 present at least partly as a ligand in a co-ordination  
complex with the metal M in the hydrolysable resin.

11. An antifouling coating composition according to any of claims 1 to 10, characterised in that it contains a pigment which is a copper or zinc compound having a solubility in seawater of from 0.5 to 100 parts per million by weight.

11. A process for preparing an anti-corrosion coating composition comprising a bis(amine) and a metal organic and comprising as binder a hydrolysable resin having at least one side chain bearing at least one terminal group of the formula:



$$\text{R}_2 = \text{C}(\text{R}_3)(\text{R}_4)\text{C}(\text{R}_5)(\text{R}_6)\text{C}(\text{R}_7)(\text{R}_8)\text{C}(\text{R}_9)(\text{R}_{10})$$
  
wherein R represents -CH<sub>2</sub>, -CH=, -CH<sub>2</sub>-CH= or -CH=CH-

12. M represents a metal having a valency of at least 2, x represents 1 or 2, and R represents a monobasic organic acid residue, characterised in that a substantially non-volatile amine is incorporated into the composition.

13. A process according to claim 12, characterised in that the amine forms a coordination complex with the metal M in the hydrolysable resin.

# INTERNATIONAL SEARCH REPORT

International Application No. PCT/GB 91/00561

## I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) \*

According to International Patent Classification (IPC) or to both National Classification and IPC

IPC<sup>5</sup>: C 09 D 5/14

## II. FIELDS SEARCHED

Minimum Documentation Searched <sup>7</sup>

Classification System	Classification Symbols
IPC <sup>5</sup>	C 09 D

Documentation Searched other than Minimum Documentation  
to the Extent that such Documents are Included in the Fields Searched \*

## III. DOCUMENTS CONSIDERED TO BE RELEVANT\*

Category *	Citation of Document, <sup>11</sup> with Indication, where appropriate, of the relevant passages <sup>12</sup>	Relevant to Claim No. <sup>13</sup>
A	EP, A, 0342276 (NIPPON PAINT CO.) 23 November 1989 cited in the application --	
A	EP, A, 0204456 (NIPPON PAINT CO.) 10 December 1986 cited in the application	
	-----	

- \* Special categories of cited documents: <sup>10</sup>
- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step
- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- "G" document member of the same patent family

## IV. CERTIFICATION

Date of the Actual Completion of the International Search  
7th June 1991

Date of Mailing of this International Search Report

International Searching Authority

EUROPEAN PATENT OFFICE

Signature of Authorized Officer

22 JUL 1991  
MISS T. TAZELAAR

ANNEX TO THE INTERNATIONAL SEARCH REPORT  
ON INTERNATIONAL PATENT APPLICATION NO.

GB 9100561  
SA 46713

This annex lists the patent family members relating to the patent documents cited in the above-mentioned international search report. The members are as contained in the European Patent Office EDP file on 16.07.91. The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

Patent document cited in search report	Publication date	Patent family member(s)		Publication date
EP-A- 0342276	23-11-89	JP-A-	63128008	31-05-88
		US-A-	4918147	17-04-90

Patent document cited in search report	Publication date	Patent family member(s)		Publication date
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		US-A-	4774080	27-09-88

